

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010604**Date Inspected:** 03-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** ZPMC**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** welder qualification tests for tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

Caltrans Quality Assurance Inspector (QAI) representative Mr. Wai Pau witnessed fifteen welders performed welder qualification tests. The qualification welding tests utilizing the Shielded Metal Arc Welding (SMAW) process were conducted by each welders performed in the vertical position (3G) and over head position (4G) . The welder test names are Mr. Hu Qi Ming, Mr. Long Zheng Gang, Mr. Tian Guan Jun, Mr. Xie Gang, Mr. Han Ying, Mr.Zhang Yuan Zhong, Mr. Xia Chang Yi, Mr. Lv An, Mr. Li Shuang Quan, Mr. Zhang Zhi Qian, Mr. Zhu Itan Sheng, Mr. Lin Chun Yang, Mr. Li Hong Ming, Mr. Zhu Li Feng and Mr. Tian Dian Wei. The material used for the welder qualification test specimens was reported by ZPMC inspector as ASTM A709M. Gr 345 plate having a wall thickness measurement of 25mm. The weld joint design used butt joint, single-V-groove weld with 75mm backing bar . The proper filler metal used in the test for SMAW is Lincoln TL-508 with 4mm diameter electrode made by Lincoln, USA. The SMAW welding process and parameters have been monitored and recorded by CWI inspectors. During qualification test welder Mr. Hu Qi Ming and Mr. Li Shuang Quan has retest on 3G and 4G positions due to weld cap excess of AWS D1.5 code allowances. Both of retest has been accepted. Base on Caltrans inspection, the welder qualification tests appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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welder qualification test (4G)



4G test samples



welder qualification test (3G)



3G test samples

Summary of Conversations:

As notes within report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045 , who represents the Office of Structural Materials for your project.

Inspected By: Pau,Wai

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer